

Date: Tuesday, 11/29/2005 6:50:17 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 25037 -2  
 Estimate Number : 10699  
 P.O. Number : N/A  
 This Issue : 11/29/2005 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : LANDING GEAR  
 Previous Run : N/A  
 Drawing Name : AFT TUBE ASSEMBLY  
 Part Number : D3391025  
 Drawing Number : D3391 REV B  
 Project Number : N/A  
 Drawing Revision : B  
 Material : N/A  
 Due Date : 12/20/2005 Qty: 5 U: Each  
 Written By : SEE COMMENT BELOW  
 Checked & Approved By : SEE COMMENT BELOW  
 Comment : Created By Auto Work Order Rev B as per Rev B

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D6014090 ALUMINUM EXTRUSION



Comment: Qty.: 1.0000 f(s)/Unit Total: 4.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty	Part Number	Description	Batch
1	D6014-090	Extrusion	B24315B

Identify as D3391-3

ml 05/12/21 5

## Tools:

2.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA Rev: AA &amp; Dwg D3391 Rev: B

ml 05/12/21 5

## Tools:

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 05/12/21 5

## Tools:

4.0 BAND SAW HAAS BAND SAW



Comment: BAND SAW HAAS

Machine as per Folio FA Rev: AA & Dwg D3391 Rev: C  
 Drill aft cap holes per Dwg D3391 using DT8803  
 Deburr

BG 05.12.23 5

## Tools:



# Process Sheet

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Drawing Name: AFT TUBE ASSEMBLY

Job Number: 25037

Part Number: D3391025

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BC 05.12.23

5

Tools:

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 05.12.23

5

Tools:

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3391

DP 06-1-13

5

Tools:

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Tools:

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Drill and c' sink wearshoe holes as per Dwg D3391

C'sink holes for float bag (4 holes per side) as per Dwg D3391

Deburr

DP

DP 06-1-13

DP 06-1-13

06-1-13

2  
2  
2

Tools:

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Tools:

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 060125

Tools:





# Process Sheet

mer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 25037

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AESS10KB366

Inventory



Comment: Qty.: 14.0000 Each(s)/Unit Total: 56.0000 Each(s)

Insert

Pick:

Qty	Part Number	Description	Batch
14	AESS10KB366	Insert	m17905

FC 06 01 26

Tools:

13.0

AESS10KB166

INSERT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

INSERT

Pick:

Qty	Part Number	Description	Batch
8	AESS10KB166	Insert	m19354

FC 06 01 26

Tools:

14.0

AESS10KB266

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

INSERT

Pick:

Qty	Part Number	Description	Batch
2	AESS10KB266	Insert	m17905

FC 06 01 26

Tools:

15.0

AESS10KB316

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

INSERT

Pick:

Qty	Part Number	Description	Batch
2	AESS10KB316	Insert	m17905

FC 06 01 26

Tools:

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Install inserts and Aft Cap as per Dwg D3391

Tools:

FC 06 01 26



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 25037

Part Number: D3391025

Job Number:



Seq. #: Machine Or Operation: Description:

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Tools:

18.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Tools:

19.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Tools:

20.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Aft Cap

Pick:

Qty	Part Number	Description	Batch
1	D2646	Aft Cap	B23370B

Tools:

21.0

AN3C4A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C4A	Bolt	m19185

Tools:

22.0

AN960C10L

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Inventory

Pick:

Qty	Part Number	Description	Batch
2	AN960C10L	Washer	m18822





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Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description:

Tools:

23.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description	Batch
2	NAS1515H3L	Washer	M17450

FC 06 01 25

Tools:

24.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Aft Cap as per Dwg D3391

A/R

Sikaflex-241/-291 M14597

Sikaflex expiry date: 06 1806

Identify as D3391-025

M 06 11 31

Tools:

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Tools:

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

C 206/02/03

(1)

Tools:

27.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Tools:

Sue 06/02/07 (2)

D 206/02/07

Job Completion



